

Date: Monday, 2/5/2007 4:02:09 PM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	30648			
Estimate Number	10313			
P.O. Number	<u>N/A</u>		Part Number	D26483
This Issue	2/5/2007	S.O. No. <u>N/A</u>	Drawing Number	D2648 REV D
Prsht Rev.	NC		Project Number	N/A
First Issue	2/5/2007	Type: SMALL /MED FAB	Drawing Revision	D
Previous Run	29777		Material	<u>N/A</u>
Written By			Due Date	2/23/2007
Checked & Approved By		<u>01.02.06</u>	Qty:	200
Comment	Est: E 02.09.18	Re-format; Incorporated D2648-1 KJ/RF	Um:	Each
	Est Rev:F	Now on Waterjet 06-08-14 JLM		

## Additional Product:

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M1010S16GA	1010/1025/A21/6aA SHEET	
		Comment: Qty.: 0.0788 sf(s)/Unit Total: 15.7500 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: <u>m104056</u> <u>ml 01 04 23</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> <u>ml 01 04 24</u> Prog Rev: <u>D</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: AD Date: 07/05/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Date: Monday, 2/5/2007 4:02:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 30648

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 07/05/03 (200)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat 10381

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC 07/05/18 (179)

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/05/18 (174)

10.0 POWDER COATING POWDER COATING



1101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07.05.22 (174)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12/05/23 (174)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

1/05/23 (174) S9

13.0 QC21 FINAL INSPECTION/W/O RELEASE



174

Comment: FINAL INSPECTION/W/O RELEASE

10/05/23

Job Completion



11/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30648
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

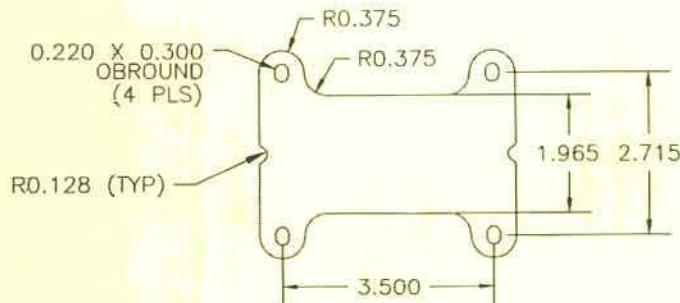
## X First Article      Prototype

Measured by:	<i>MM</i>	Audited by:	<i>AD</i>	Prototype Approval:	N/A
Date:	07/04/24	Date:	07/04/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



D2648-1 FLAT PATTERN



SECTION A-A

R1.62

7560 HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

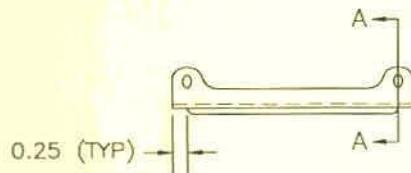
0.50

SECTION B-B

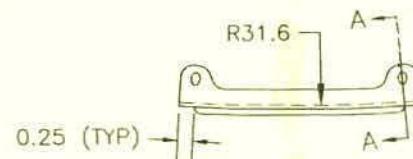
R1.62  
0.12 (TYP)  
0.13  
0.10

D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

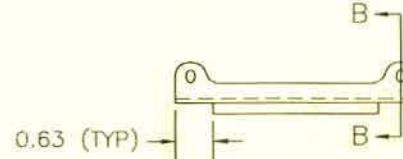
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

NO. 30268  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
IN CONTROLLED COPY  
ENGINEERING  
RETURNS TO  
SHOP COPY

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBRound, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGNER <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE USA, INC. BELLMA, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2648 REV. D SHEET 1 OF 1
DATE 99.11.17	TITLE WEARPAD	SCALE 1:2

RELEASED  
199.12.20 DS



